#### \* Work Order ID 73620

Wednesday, September 07, 2011 2:37:20 PM

Item ID:

D3183-045

**Revision ID:** Item Name:

Bearing Assembly

**Start Date:** 

9/7/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



Accept



Setup Start

Stop

Reference:

Required Date: 9/21/2011

Approvals:

Process Plan:

QC:

Date: Date: **Tooling:** 

SPC (Y/N):

Date: Date:

**Cust Item ID:** 

**Customer:** 

Run

Start

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**  Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

**Revision Nbr** 

D3183

100

Rev C1

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

Pa 11.7.8

12

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA388 Deburr

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

29 11.9.8

Memo

0.00

120

0.00

on Lulos/02

Memo

QC8- Inspect parts - second check

0.00

Quality Control

QC

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	NGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		\$		<del> </del>							
Part No	:	PAR #:	Fault Cate	Category: NCR: Yes No DQA: Date: Distion: QA: N/C Closed: Date:  DRDER NON-CONFORMANCE (NCR)							
	Re	esolution:	Disposition	on:	QA: N	VC Clo	sed:		Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (	NCR)					
DATE	STEP	Description of NC	1	tion B	Sian 0	Verification		Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	•	Sign & Date	Secti	on C	Chief Eng	QC Inspector	
									•		
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NOTE: Date & initial all entries

#### Work Order ID 73620

Wednesday, September 07, 2011 2:37:20 PM

Item ID:

D3183-045

**Revision ID:** 

Item Name:

Bearing Assembly

**Start Date:** 

9/7/2011

Start Qty: 10.00 Required Date: 9/21/2011

Req'd Qty: 10.00

Reference:

Approvals:

Sequence ID/

**Process Plan:** 

QC:

Date:

Date:

SPC (Y/N):

Tooling:

Set Up/ **Run Hours** 

0.00

Small Fab

Work Center 1D

Small Fab

Small Fab

130

Memo

Operation

**Description** 

0.00

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

Accept

Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

Date:

Date:

Run

Start

Stop

Tool ID

Tool # Plan Code

Accept **Qty** 

**Qty** 

Reject

Reject Number

Insp. Stamp

140

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: 57 3

0.00

150

Packaging Packaging

Memo

0.00

Sp 11-09-08

W/O:	-		WO	RK ORDER CHANG	ES					. 4		
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	, ,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No.	•	DAD #-	Fault Cotos	lory:	NCP: V	os N	· DO	۸.	Data			
Part No: PAR #:			Disposition:									
	nes						ea:		Date: _			
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A			ion B	0	Verification		Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C	on C	Chief Eng	QC Inspector		
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						<u>-</u>						
1												

NOTE: Date & initial all entries

#### Work Order ID 73620

Wednesday, September 07, 2011 2:37:20 PM

Item ID:

D3183-045

**Revision ID:** 

Item Name:

Bearing Assembly

**Start Date:** 

9/7/2011

**Start Qty: 10.00** 

Operation

Description

Req'd Qty: 10.00 Required Date: 9/21/2011

Reference:

Approvals:

**Process Plan:** 

QC:

Date:

Date:

SPC (Y/N):

**Tooling:** 

Set Up/ **Run Hours** 

0.00

QC21- Final Inspection - Work Order Release

Sequence ID/

160

Work Center ID

Quality Control

Memo

0.00

Accept

Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Tool ID

Date:

Date:

Run

Start

Stop

Tool# Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

11-09-08

W/O:		WORK ORDER CHANGES							<		
DATE	STEP		PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
:									ļ		
								<u> </u>			
Part No	):		PAR #:	Fault Category:	NCR	: Yes	No DQ	A:	Date: _		
	F	Resolution:		Disposition:	QA:	N/C C	Closed:		Date: _		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal				
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	Approval QC Inspector				
							·					
						·						
								·				
					***							
NOTE: D	ate & initial	all andrian										

### **Picklist Print**

Wednesday, September 07, 2011 2:37:17 PM

Work Order ID: 73620

Parent Item:

D3183-045

Parent Item Name: Bearing Assembly



Start Date: 9/7/2011

Required Date: 9/21/2011

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP A 04.02.18 New issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 Bearing	<b>        </b>	Manufactured	No			110	Each	78.0000		10 \$\int_{1}	1/09/	68	
		•		Location		Loc (	<u>Oty</u>	Loc Code			•		
				ST235B			50		_		-		
					71854		50				-		
				ST236			28				-		
					67529		1		_		_		
					68933		4		_		-		
					72295		23		_	62	_		•
MDELRINR 1.000		Purchased	No			130	f	41.2180	0.0333	0.350526			

Delrin Round Bar 1"

Location		Loc Qty	Loc Code
MAT055		41.218	
117985	*	0.407	
118257 <b>V</b>		24.811	
118392		16	

	P									
W/O:			WC	ORK ORDER CHANG	ES		-			* ,
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	(	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				:		,				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es No	DQ/	<b>\</b> :	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C	Clos	ed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Section	on C	Chief Eng	QC Inspector
-	į									
						٠				
	1									
	1									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73670	
Description: Cap	Part Number:	D3183-9	
Inspection Dwg: D3183 Rev: C1		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.830	+/-0.005	े ६ डे ३			RQ. 22	-
Ø0.720	+/-0.002	721				
Ø0.747	+/-0.001	.748				
R0.010	+/-0.010	002				
R0.031	+/-0.010	1.021				
0.199	+/-0.001	. ( 99				
0.276	+/-0.010	, 277				
0.039	+/-0.010	.039				
						·
						į
			i			

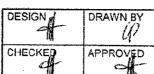
Measured by: 🔎	Audited by:	onl	Prototype Approval:	N/A
Date: U. G. C	Date:	11/09/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	1
В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM ZA	011
			TOTOLINI CALL	





DATE



DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3183

TITLE

REV. C

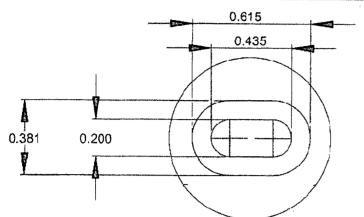
SHEET 4 OF 4

**BRACKET ASSEMBLY** 

SCALE

1:1

04.02.17



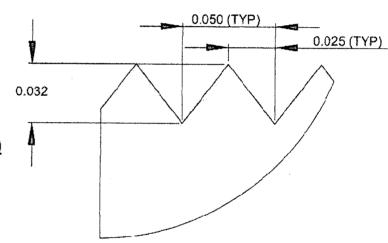
**DETAIL A (2:1)** 

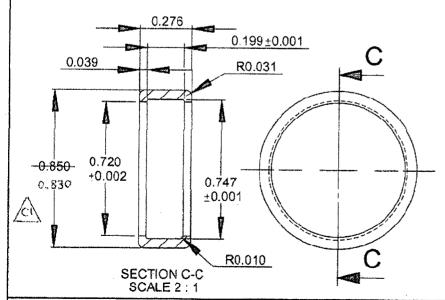
w/0 72620

RELEASED

DEO ATTACHED

**DETAIL B (20:1)** 





#### D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00) 2) TOLERANCES ARE PER DART QSI 018
- UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

## D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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